

Date: Wednesday, 05/11/2008 3:24:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ESCAPE PANEL PUSH OUT WINDOW
 Job Number : 43224
 Estimate Number : 12853
 P.O. Number :
 This Issue : 05/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 42119
 Part Number : D412709013
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material :
 Due Date : 07/11/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JLD 08.11.05
 Comment : Est Rev:A New Issue 07-05-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



A for JLD 08.11.14



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD412-709-013 CHG001

Sosuliy

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3136043 Window Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Window Assembly

Batch:

B349413

SS 08/11/14

4.0 D32371 Seal Retainer



Comment: Qty.: 8.5749 f(s)/Unit Total : 8.5749 f(s)

Seal Retainer 98" long

Batch:

43183

New Batch

SS 08/11/14

5.0 D32373 Seal Filler



Comment: Qty.: 8.5743 f(s)/Unit Total : 8.5743 f(s)

Seal Filler 98" LONG

Batch:

43140

New Batch

SS 08/11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ESCAPE PANEL PUSH OUT WINDOW

Job Number: 43224

Part Number: D412709013

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

D35611

Seal Insert Tool



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WINDOW SEAL TOOL

Batch:

4447 41813

SS 08/11/14 (X1)

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/11/14 (X1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412709-013

Location:

PPP Rev:

A 08/11/14 (X1)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/14 (X1)

Job Completion



MF 08-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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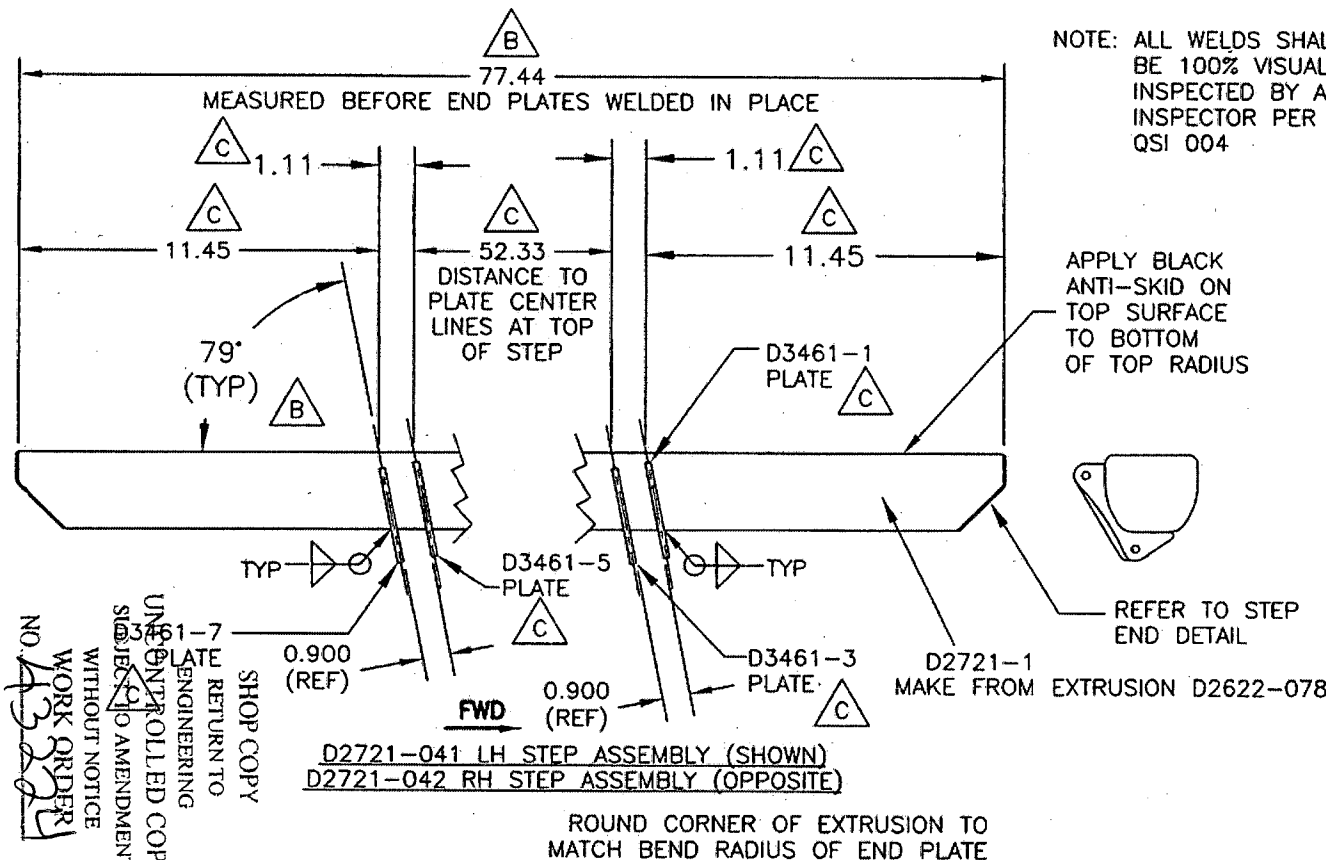
NOTE: Date & initial all entries



RELEASED
05.11.14

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, VA
DATE	05.09.19	TITLE	D2721	RE-DESIGN, ADD D3461-1/-3/-5/-7
05.09.19		206B STEP ASSEMBLY		
		NEW ISSUE		
		79° WAS 80°, UPDATED WELD DETAIL, REVISED TOLERANCES, 53.44 WAS 54.0		
		SCALE		
		NTS		

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
X	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

